

What is claimed is:

1. A crystalline venlafaxine base in the form of white crystals, wherein the venlafaxine base has a purity of at least about 97%.
5. A crystalline venlafaxine base in the form of white crystals, wherein the venlafaxine base has a purity of at least about 98%.
3. A crystalline venlafaxine base in the form of white crystals, wherein the venlafaxine base has a purity of at least about 99%.
4. A crystalline venlafaxine base in the form of white crystals, wherein the venlafaxine base has a purity of at least about 99.3%
10. 5. A crystalline venlafaxine base in the form of white crystals, wherein the venlafaxine base has a purity of at least about 99.5%.
6. A process for preparing a crystalline venlafaxine base having a purity of at least about 97% comprising the steps of: 1) preparing a mixture of N,N-didesmethyl venlafaxine in a first organic solvent; 2) adding a basic solution selected from the group to the mixture to adjust to a basic pH; and 3) extracting the venlafaxine base with a second organic solvent.
15. 7. The process according to claim 6, wherein the purity is at least about 98%.
8. The process according to claim 7, wherein the purity is at least about 99%.
20. 9. The process according to claim 8, wherein the purity is at least about 99.3%.
10. 10. The process according to claim 9, wherein the purity is at least about 99.5%.
25. 11. The process according to one of claims 6-10, where the basic solution is selected from the group consisting of sodium hydroxide and potassium hydroxide.
12. The process according to one of claims 6-10, wherein the first organic solvent is formic acid and formaldehyde.

13. The process according to one of claims 6-10, wherein the second organic solvent is selected from the group consisting of toluene and heptane.

14. The process according to one of claims 6-10, further comprises drying the second organic solvent to dryness.

5 15. The process according to claim 14, wherein the drying is carried out by heating or under vacuum.

10 16. The process according to one of claims 6-10, further comprising the step of 4) crystallizing venlafaxine base from a solvent selected from the group consisting of hexane, pentane and petroleum-ether.

17. A crystalline venlafaxine base having a purity of at least about 97% produced according to one of claims 6-10.

18. A crystalline venlafaxine base having a purity of at least about 98% produced according to one of claims 6-10.

15 19. A crystalline venlafaxine base having a purity of at least about 99% produced according to one of claims 6-10.

20. A crystalline venlafaxine base having a purity of at least about 99.3% produced according to one of claims 6-10.

21. A crystalline venlafaxine base having a purity of at least about 99.5% produced according to one of claims 6-10.

20 22. A process for preparing venlafaxine hydrochloride Form I, comprising the steps of:

25 1) preparing a mixture of venlafaxine in isopropanol; and
2) introducing hydrochloric acid until a pH is in the range of pH about 5 to about 8.

23. The process according to claim 22, wherein the pH is between pH about 6 to about 7.5.

24. The process according to claim 22, wherein the pH is about 7.

25. The process according to claim 22, wherein the hydrochloric acid is a gaseous hydrochloric acid.
26. The process according to claim 22, wherein the venlafaxine is a venlafaxine base.

5 27. The process according to claim 22, wherein the mixture is a homogeneous solution of venlafaxine.

10
15
20
25
30
35
40
45
50
55
60
65
70
75
80
85
90
95